VCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
		-

								•		QA Closed:	. Date:	₹ •
Work Ord	er:				DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Part I	No				Rework Scrap Use-as-is Work Order Update	Th	Ma nermo	kid-tube achining forming arge Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	al	. Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Desc	ription	' Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						Ì						
Operator			i									
Material												
Setup												
Other												·
Process												
Supplier												
Training							ļ					
Unapproved												
	<u> </u>				F <i>I</i>	AULT CA	ATEGO	DRY				
Landi	ng Gear				General					_		_
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
İ	Centre N	Not Concer	ntric to	O/S	BOM/Route	Hard	dware			Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged			Incomplete	_	Part Incorred	ct <u> </u>	Weld
		/Crimped.			Burrs	${f m m m m m m m m m m m m m $		ns Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ļ	Cuffs Contamination					—	intena			Part Moved		
	Heat Treat Countersink					Misl	labele	d		Positioned V	Vrong	_
	Inspection Strip in Tube Cut Too Short					\vdash	read			Power Loss/	Surge	Other
Ripples in Bend Drill Holes					Offs							
Torque Waves in Extrusion Drawing					Out of Calibration							
	Turning Sequence Finish					Out	of Sec	quence				
	Wave/Twist in Tube Folio					Outs	side D	imensions		-		

150

Quality Control

Memo

QC

NCR: Ye	s / No				WORK ORDER NON-	CON	NFORM	MANCE / UPDATE		•		2
					T					QA Closed:	Date:	*
Work Order	:				DISPOSITION	_		AG	AINST DE	PARTMENT/	PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		Therm	Machining Sma	sstube all Fab nishing posite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
IVEN IVE	·			-	Work Order opdate	┚╏		Large rab Com	posite	J	3upplier	└ <u></u>
Root Cause	Date	Step	Qty	L	iption of work order update or Non-conformance		nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining napproved							75 3.					
				•	F	AUL	T CATE	GORY				
Landing	Bending Gear General Bending Bend Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing					Instructi Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
<u> </u> -	Turning S				Finish	-	l	equence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Work Orde				*93	3254*					Page 3				
Item ID: Revision ID: Item Name:	647.7917 Bracket			Accept	*N9	nnn	40	100)*	Setup	Start Stop	*N.	S1* S2*	-
Start Date: Required Date: Reference:	11/15/12 12/07/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*	·	Cust Custo	Item ID: omer:				•				,
Approvals:	Process Pla	an:	Date:	Tooling:		Date	*			Run	Start	*N	R1*	
	QC:		Date:	_ SPC (Y/N):		_ Date	:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hour	Too	l ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp	-
160		Outsource process-Anoc	tize per QSI017 4.1.10.1	0.00									_	
160 Outsource4 Outsource process -	Anodize	Memo ISSUE P/O HARD AN	: 1940 4 odize, color black	0.00 AS PER DWG.(SEE	NOTE 2)				_C	L 13	63/5) 2	(3).	
170		Receive & Inspect for D	Damage & Mat'l Certs	0.00										
170 Packaging Packaging		Memo .		0.00				٠	<u> </u>	<u> </u>		``	3-4-	Ć
180		QC5- Inspect part comp	oleteness to step on W/O	0.00	AS 27				2			·	1	
1 2 0		Memo		0.00	42				2					

Quality Control

										DQA:	Date:	ę	
NCR: Ye	es / No				WORK OR	DER NON-C	ONFORI	MANCE / UI		QA Closed:	Date:	,	
Work Order	:		,		DISP	OSITION			AGAINST DE	PARTMENT	/PROCESS	,	
Part No.					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing					Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No	D				Work Or	Use-as-is der Update	mem	Large Fab	Finishing Composite	Rec/Stor	Supplier	Other	
Root				Descri	ption of work o	ion of work order update Initial Action Sign &							
Cause	Date	Step	Qty		or Non-conform	nance	Chief Eng	Des	cription	Date	Verification	QC Inspector	
Doc/Data					•								
Equip/Tooling	_	<u> </u>				i							
Operator		-										•	
Material													
Setup] .		,	-						
Other		1		 .								τ *	
Process								,					
Supplier										1			
Training													
Unapproved													

FAULT CATEGORY

Grain'

General

Bend

BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Inspection Incomplete Part Incorrect Cracks Weld Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Maintenance Contamination Part Moved Mislabeled Positioned Wrong **Heat Treat** Countersink Misread Other Inspection Strip in Tube Cut Too Short Power Loss/Surge Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Out of Calibration Drawing Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Ovalized

Pressure/Forced

Landing Gear

Bending

Work Order	ID	93254	
November-15-12	10:37:0	05 AM	

November-15-12				*93254*									an attended	Page 4
Item ID: Revision ID:	647.7917	· .		Accept		*N	900	040	100)*	Setup	Start	*N	S1*
Item Name:	Bracket											Stop	*N:	S2*
Start Date:	11/15/12	Start Qty: 3.00	*3	*		Cu	st Item l	D:						4
Required Date:	12/07/12	Req'd Qty: 3.00	*3	*		Cu	stomer:							
Reference:									_		D	Start		
Approvals:	Process Pla	an:	Date:	Toolin	ıg:		D	ate:	_		Run		1/1	R1*
	QC:		Date:	SPC (SPC (Y/N):		Date:					Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Ru	Up/ n Hours	Γ	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
190				0.00										10 :
100 SprayPaint		Memo		. 0.00				•		3		Ø	_Ø	13-4-5
Spray Painting		,	V MIL-P-23377J TY		. * .	(SEE NOTE	: 2)							
		CARDINAL	_ 4860-50 PRIMER	ватсн: <u>12</u>	1204									
200		QC14- Inspect Spray Pai	int	0.00					٠,	0			(DAS. 05 13.04
200		Memo		0.00	ı					3				8-89 / /).04
Quality Control		Memo									*			•
												٠		
210	,	Identify as per dwg & St	ock Location:	0.00					-					(2)
210 Packaging		Memo		0.00) ·						_(_	79	14/9	3/
Packaging		***IDENTI	FY AS PER APICA	L MPP-120 BY S	TAMPING P	# AND REV	***							

NCR:	Vac	/	No
IVCIV.	163	,	INU

DQA:

Date:

NCR:	ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
		•										QA Closed:	Date:	
Nork Ord	er:		_				DISPOSITION				AGAINST DI	PARTMENT,	PROCESS	
Part I	٠ ١٥٠ ₋						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing					Pro Rec/Stor	Engineering Quality Other	
NCR i	No.		· · · · · ·				Work Order Update			Large Fab	Composite]	Supplier	
Root					Des	cri	otion of work order update	ı	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data quip/Tooling perator														
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upplier														
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napproved								<u> </u>				<u>l</u>		
	1						F	AUL	T CATE	GORY				
Landi	ng G	iear					General	_			_	_	_	
		Bending					Bend	L	Grain			Ovalized		Pressure/Forced
	Ц	Centre No	t Concer	ntric to (D/S		BOM/Route	L	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure
	\vdash	Cracks					Broken/Damaged		1	on Incomplete		Part Incorred	<u> </u>	Weld
	-		ed/CrimpedBurrs						•	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled .
		Cuffs	Contamination						Mainte		<u> </u>	Part Moved		
	-	Heat Treat				_	Countersink	_	Mislabe		<u> </u>	Positioned V		ا ۔
•	$\overline{}$	Inspection		Tube		_	Cut Too Short	<u> </u>	Misread	i	Ĺ	Power Loss/	Surge	Other
		Ripples in					Drill Holes	\vdash	Offset					
		Torque W		xtrusior	1		Drawing	-	1	Calibration		-		
	- 1	Turning Se	equence			l	Finish	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde	•			*93				Page			
Item ID: Revision ID: Item Name:	647.7917 Bracket			Accept	*N900	<u>040</u>	100)* s	Setup Star Stop		S1* S2*
Start Date: Required Date: Reference:	11/15/12 12/07/12	Start Qty: 3.00 Req'd Qty: 3.00	*3*		Cust Item II Customer:) :		_			,
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		te: te:			Run Star Sto	" !\]	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

220

Quality Control

Page 5

			DQA:	Date:
JCR.	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		-

NCR:	Yes	/ No				WORK ORDER NON-C	LOIN	FURI	VIANCE / UPI	DATE	QA Closed:	Da	te:
Work Order:				DISPOSITION AGAINST			AGAINST DE	DEPARTMENT/PROCESS					
	- _ No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root				_	Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verificatio	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
онарриотеа				l	l	F/	AULT	CATE	GORY			<u> </u>	, I
Landi	ng G	ear				General							· · · · · · · · · · · · · · · · · · ·
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled		Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
	-	Inspectior		rube	-	Cut Too Short	-	Misread	1		Power Loss/	Surge	Other
	Ripples in Bend Torque Waves in Extrusion		Drill Holes Drawing	—	Offset Out of Calibration								

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Page 1

Work Order ID:

93254

Parent Item:

647.7917

Parent Item Name:

Bracket

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			110	sf	244.4200	0.163	0.5147368 O.G.			Jm 12-11-2
				Location		Loc Oty	Lo	c Code		**			
				MAT022		244.42							
				119	916	0.1							
				121	197	16.32							
				123	654	36			153	<u> </u>			
				123	701	192							

			DQA:	Date: _	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

-									QA Closea:	Date	:	
Work Orde	er:				DISPOSITION			AGAINST DE	DEPARTMENT/PROCESS			
Part No.			Rework Scrap Use-as-is	The	Skid-tube Machining moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other			
NCR No			Work Order Update		Large Fab	Composite	,	Supplier				
Root			· ·	Descri	ption of work order update	Initial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector	
Doc/Data											,	
Equip/Tooling												
Operator												
Material					1							
Setup												
Other												
Process	_											
Supplier						ļ						
Training	_											
Unapproved		1	l			1117 647						
						AULT CAT	EGORY				1	
Landii	ng Gear				General Bend	Grain			امست	Г	Pressure/Forced	
	Bending	- . C		~/c	BOM/Route	Hardy		<u> </u>	Ovalized Over/Under	+-l-r-n	Temperature/Cure	
	Centre No	ot Concer	itric to t	^{5/3} -	Broken/Damaged	\vdash	vare ction Incomplete	<u> </u>	Part Incorre		Weld	
	Crushed/	Crimpad		-	Burrs	⊢	ction incomplete/l	Uncloar	Part Lost/Mi		Wrong Stock Pulled	
	Cuffs	cimpea.		-	Contamination	-	tenance	Officieal	Part Moved	23311g		
	Heat Trea	ot .		\vdash	Countersink	Misla		 	Positioned V	Vrong		
			Tube		Cut Too Short	Misre		<u> </u>	Power Loss/		Other	
Inspection Strip in Tube Ripples in Bend			Drill Holes	Offse		<u> </u>	1. 04461 6033/		100.00			
ŀ	Torque W		xtrusio	, <u> </u>	Drawing	\vdash	f Calibration				;	
}	Turning S		33.31	·	Finish		f Sequence					
			Folio	_	de Dimensions							

SHOP CUPY REITERNIG ENGINEES13G UNCONTROLLIBO - G. SUBJECT TO Alexander WITH OLD WITH NO 93759 MLJ

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SIZE PROPERTY OF APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHICH WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

LAST PROTOTYPE REVISION POST NC NEW PERENT

NOTES:

MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

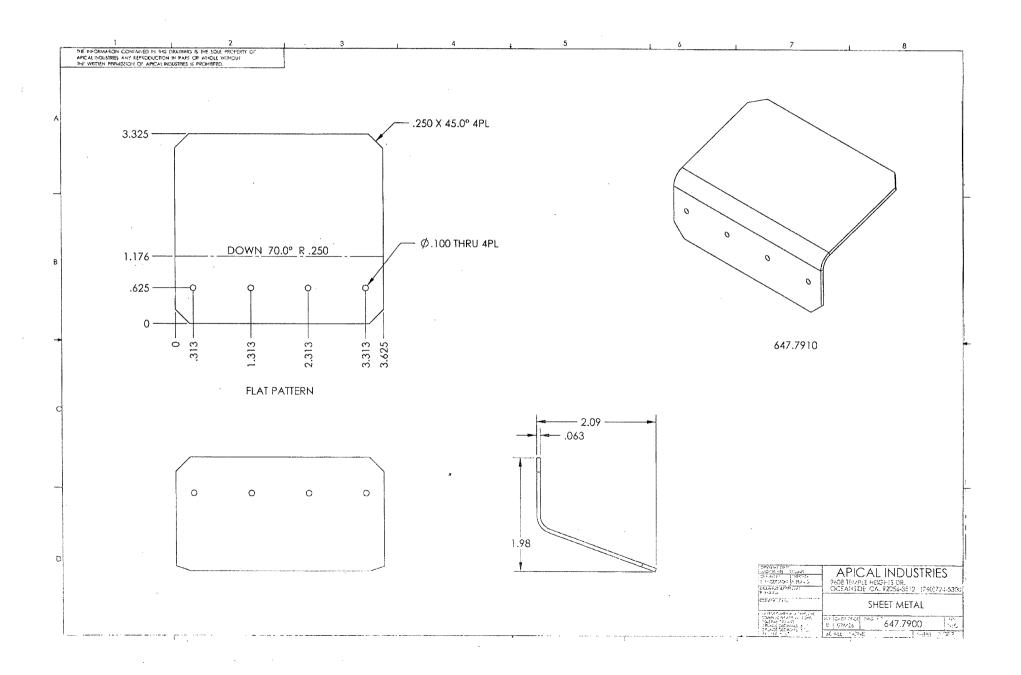
FINISH: ANODIZE PER MIL STD-A-8625, TYPEIII, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377 J TYPE I CLASS N

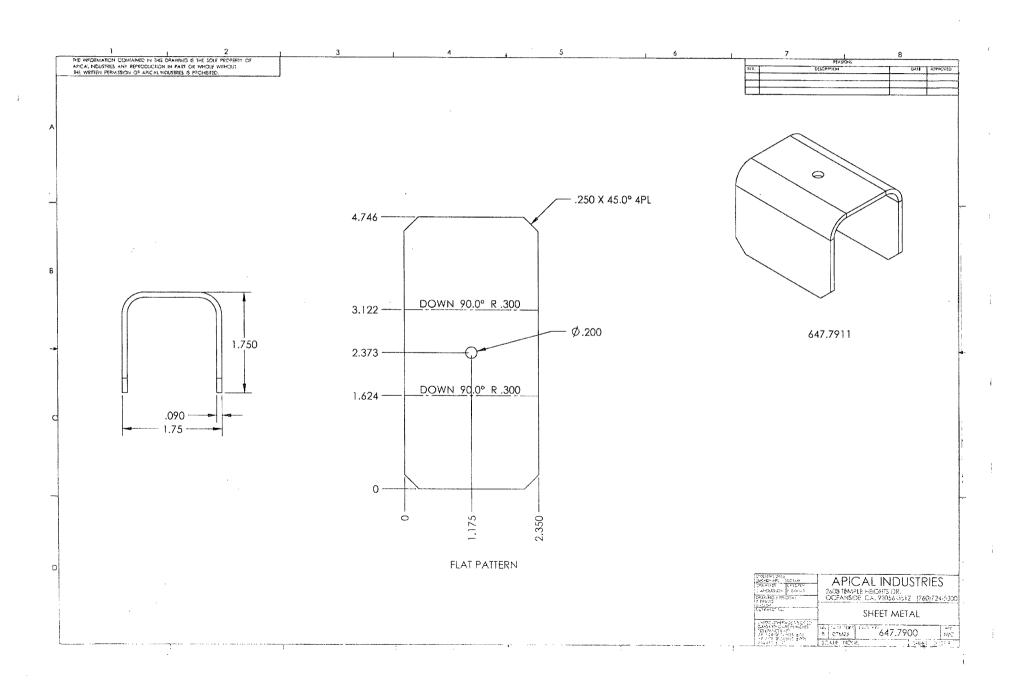
- DEBURR AND BREAK ALL SHARP EDGES
- IDENTIFY IAW MPP-120

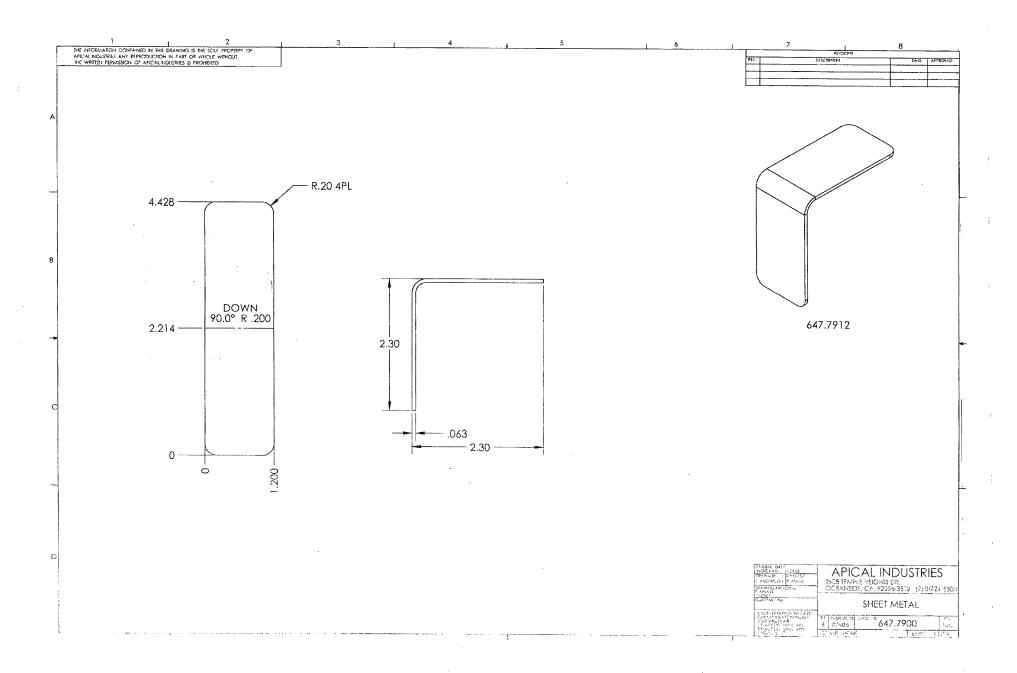
	647.7919	SHIM		Δ
	647.7918	BRACKET		
	647.7917	BRACKE!	Δ	A
	647.7916	BRACKET		A
	647.7915	BRACKET		<u>A</u>
	647.7914	BRACKEI		- A
	647.7913	DOUBLER	Δ	Δ
	647,7912	CUP		<u> </u>
	647.7911	BRACKET		A
	647,7910	ANGLE BRACKET		<u> </u>
F/14	PARTA	DESCRIPTION	MATI	SPEC
Q1Y	L	PARIS LIST		

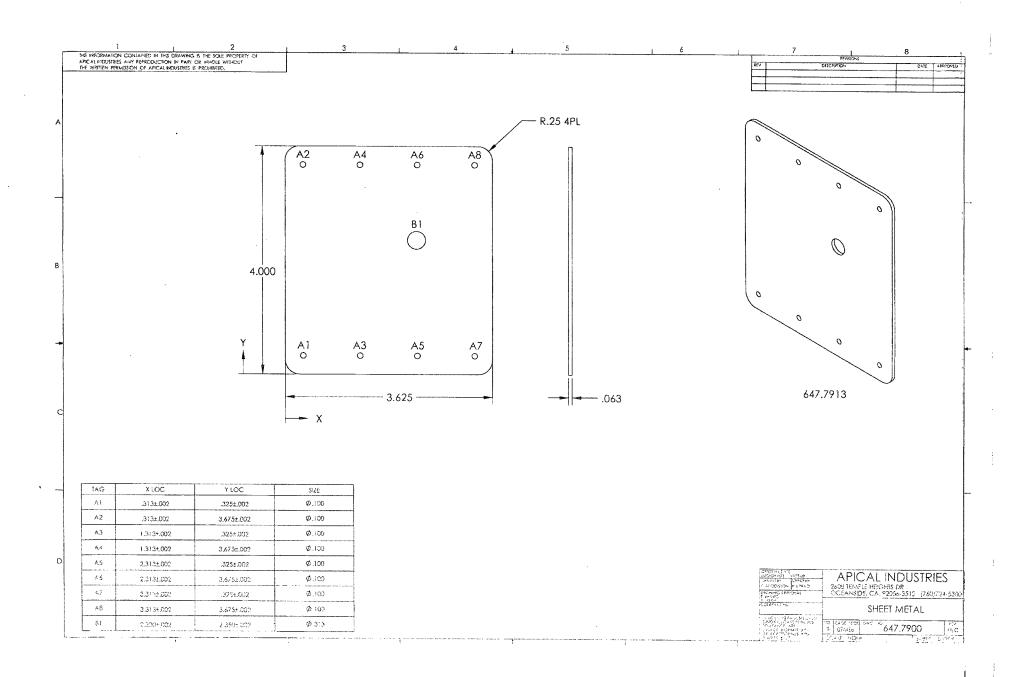
APICAL INDUSTRIES 2606 TEMPLE HEIGHTS DR. CCEANSIDE CA. 92056-3512 (260)7/46-13724

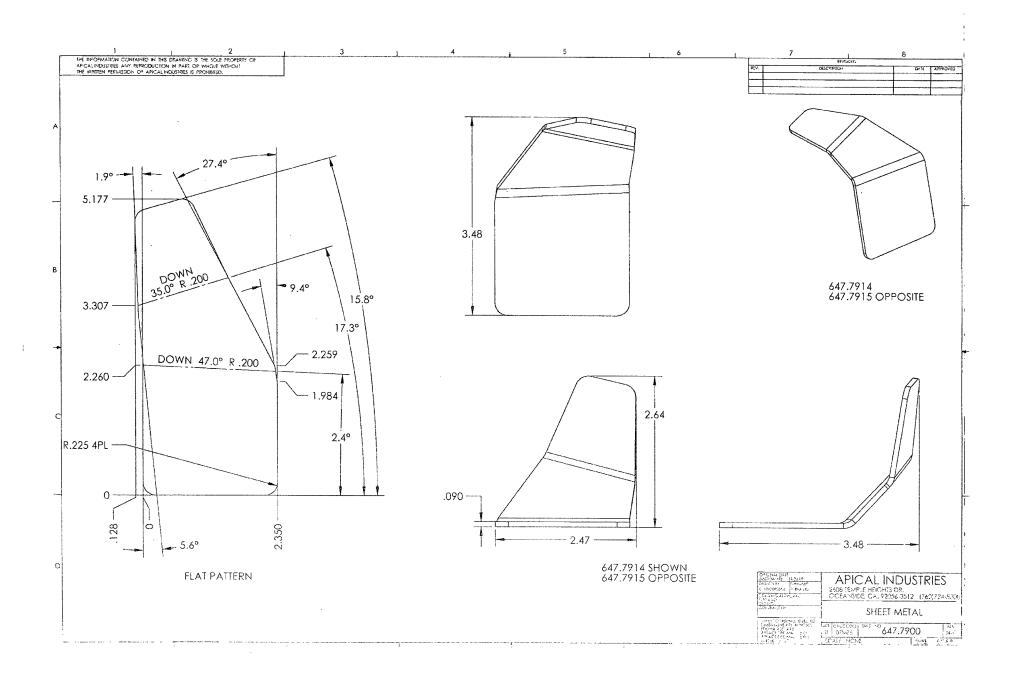
SHEET METAL

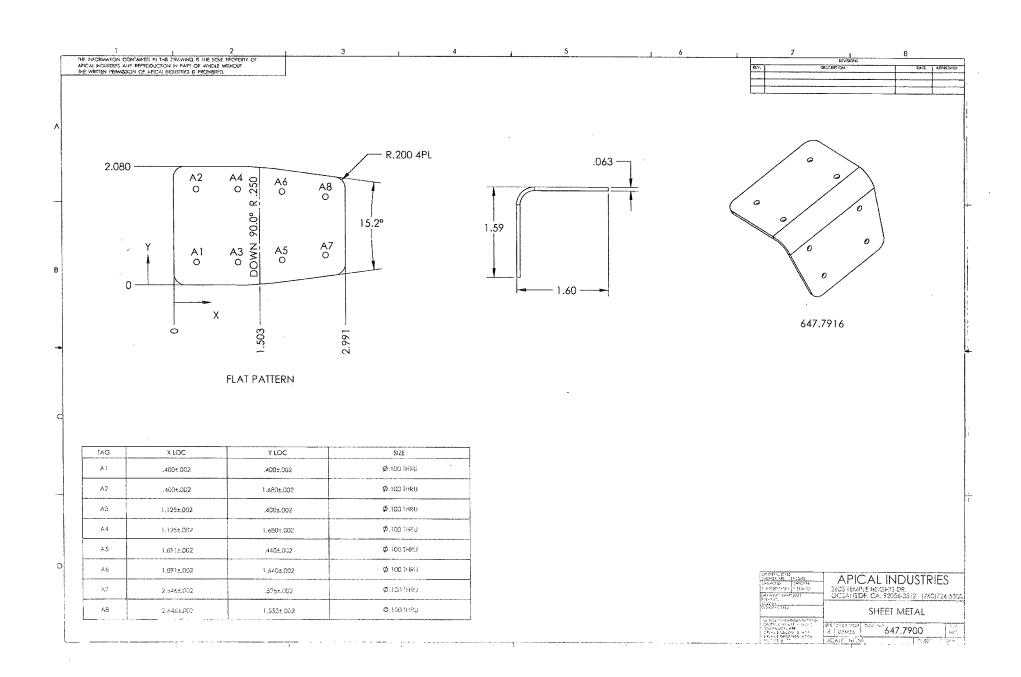


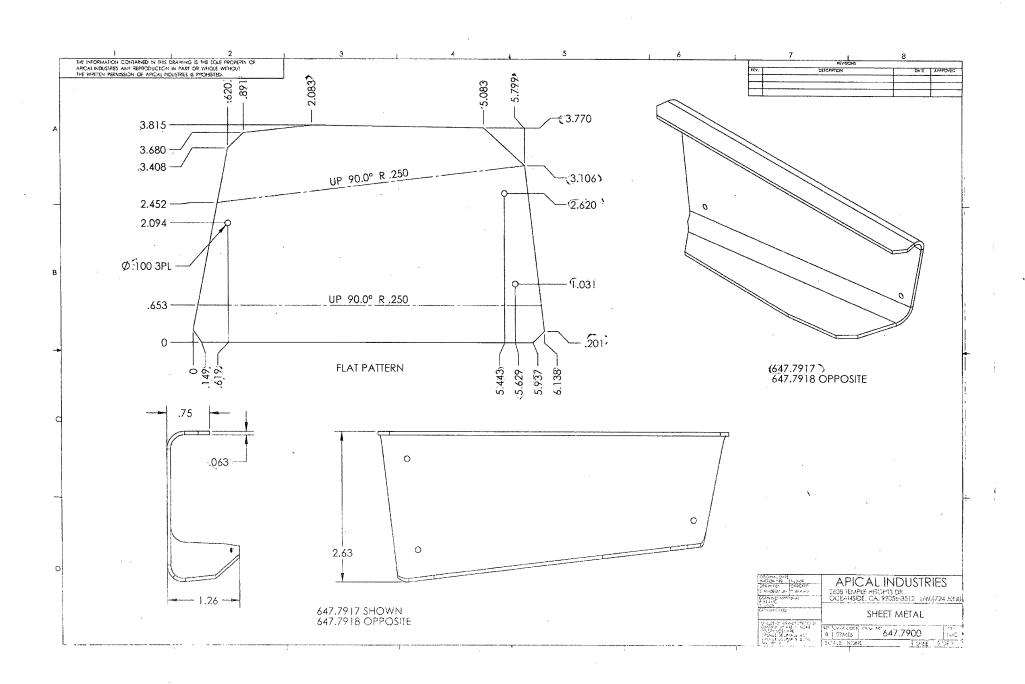












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2605 IFMALE HEIGHTS DR.
OCEANSON, CA. 97056-83312 17401724, SEID SHEET METAL

15226

DART AEROSPACE LTD	Work Order:	93754
Description: Bracket	Part Number:	647.79117
Inspection Dwg: 647. +900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing		ARTICLE IN				<u> </u>
Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments
Ø0,100"	+0.004"	٥.			V	Producer
2.094" .	th- 0.005"	2.096"	_		J	
3408"	41- 0 vos"	3408"		e e	√ ·	
3 680°	11-0.005"	3.660"	-		V.	
3.815"	4- 0.005	3.817"	-		~	
6.670"	11-0.05	0620	v		V	
0.891	+1-0005ª	0891	v		V	
7.083	tt-0.005"	2.0837			ν	
5.083"	"צטנים -וד	5.083"	ا سا		V	
5,799"	11-0.005	5,799"	_		V	4 1
3.770	41-02005	3.772"	_		V	
3.160"	4-0005	3.160	~		V	
7.620"	4-0.005"	2.623"		-te	V	
1.031"	H-0005	1,033	_		V	
0.201"	th 0.005°	0.201			V	
0.149"	4-0-005	0.149"	<u> </u>	·	V	
6.619"	1/0.005	0,622)		V	`
5.4435	4-0005	5.445	-		V	
5,629"	# orgon	6.632°	-		V	
5,937	4-0.005"	5,937	•		V	
હિ. (35*	4-0005	6,139"	. —		V	
6.063"	th-0000	0.063)		ν	
		$I_{ij} = P_{ij} \cdot \mathbb{Z}_{2}$				
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Measured by:	Jm
Date:	12-11-25.

	r	15
-	Audited by:	\$-89
	Date:	12-11-26

Preliminary Appı	val:
· ·	ate:



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62282

Date: 26-Mar-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-52	00 Fax: 613-632-1185	Ph: 613-632-5200	Fax: 613-632-1185
Terms	Ship	Via	
Quantity	Description		
1 lot	Part: ASST 3 PCS 647.7918 3 PCS 647.7917 4 PCS 41232-200-002-001 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 24 PCS D2348 20 PCS D2428 8 PCS D4726-1 20 PCS D2056 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2	Rev:	
	8 PCS D3299-7 BLUE ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20130177	19404 Line:	
	A.T.G. Industries certifies that all items in this sill with all requirements, specifications and drawing ISO 9001 : 2008 REGISTER! ATG SALES-2010 TERMS AFD DATE : 26/3/13 CERTIFIED SIGNATURE : MACE RECEIVER SIGNATURE : MACE	nipment are in conformance gs referenced in the purchase order.	